

Work Order ID 112274

January-30-14 11:25:20 AM

\*112274\*

Ship Monday

Page 1

Item ID: D3575-1

Accept

\*N900040100\*

Setup

Start \*NS1\*

Revision ID:

Item Name: Cargo Floor Protector

Stop

\*NS2\*

Start Date: 1/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: M-L5

Date: 14-01-31

Tooling:

Date:

Run

Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3575	Rev A								

100

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

1 0 Jm14-04-8

FLOW CNC Waterjet

\*\*\*TEXTURE SIDE UP\*\*\*

1-Cut as per Dwg D3575

Dwg Rev: A

Prog Rev: A

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

Memo

0.00

Quality Control

1 0 Jm14-04-8

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

**DISPOSITION**

Rework  
Scrap  
Use-as-is  
Suspected Unapproved

**AGAINST DEPARTMENT/PROCESS**

Skid-tube  
Machining  
Thermoforming  
Large Fab

Crosstube  
Small Fab  
Finishing  
Composite

Water Jet  
Prod. Eng. Coor.  
Rec/Store/Packaging  
Supplier

Engineering  
Quality  
Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General			
Bending	Bend			
Centre Not Concentric	BOM/Route			
Cracks	Broken/Damage/Defect			
Crimp/Kink/Ripple/Wave	Burrs			
Cuffs	Contamination			
Crushing	Countersink			
Heat Treat	Cut Too Short			
Inspection Strip in Tube	Drawing			
Marks/Chatter	Drill Holes			
Turning Sequence	Finish			
Wave/Twist in Tube	Fit/Function			
	Folio/Program			
	Grain			
	Hardware			
	Inspection Incomplete/Unqualified			
	Instructions Incomplete/Unclear			
	Misaligned/off center			
	Mislabeled			
	Misread			
	Off-set			
	Out of Calibration			
	Out of Sequence			

**Work Order ID 112274**

January-30-14 11:25:20 AM

**\*112274\***

Page 2

**Item ID:** D3575-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Cargo Floor Protector

Stop

**\*NS2\***

**Start Date:** 1/30/14    **Start Qty:** 1.00    **\*1\***

Cust Item ID:

**Required Date:** 1/30/14    **Req'd Qty:** 1.00    **\*1\***

Customer:

**Reference:**

**Approvals:**

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

120

**\*120\***

QC

Quality Control

130

**\*130\***

Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

140

**\*140\***

QC

Quality Control

Set Up/  
Run Hours

0.00    27  
9.89

0.00    *M4/8*

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

*J*

0.00

0.00

0.00

0.00

DAS  
27  
9.89  
*WT*

\_\_\_\_\_

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\_\_\_\_\_

DQA: \_\_\_\_\_

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

**DISPOSITION**

Rework  
Scrap  
Use-as-is  
Suspected Unapproved

**AGAINST DEPARTMENT/PROCESS**

Skid-tube	Crosstube	Water Jet	Engineering
Machining	Small Fab	Prod. Eng. Coor.	Quality
Thermoforming	Finishing	Rec/Store/Packaging	Other
Large Fab	Composite	Supplier	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General									
	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
	Crushing	Countersink	Misaligned/off center	Positioned Wrong						
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other					
	Inspection Strip in Tube	Drawing	Misread							
	Marks/Chatter	Drill Holes	Off-set							
	Turning Sequence	Finish	Out of Calibration							
	Wave/Twist in Tube	Fit/Function	Out of Sequence							

**Work Order ID 112274**

January-30-14 11:25:20 AM

**\*112274\***

Page 3

Item ID: D3575-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Cargo Floor Protector

Stop

**\*NS2\***Start Date: 1/30/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg &amp; Stock Location:

0.00

**\*150\***

Packaging

Packaging

Memo

PP112948

0.00

1/7/14 ① DAS  
32  
9-89

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Quality Control

Memo

0.00

MLC 14-04-09

MF  
14-4-8

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

# **WORK ORDER NON-CONFORMANCE / UPDATE**



**QA Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

## Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure Weld <input type="checkbox"/> Wrong Stock Pulled					
									<input type="checkbox"/> Other		

# Picklist Print

January-30-14 11:25:20 AM

Page 1

Work Order ID: 112274

Parent Item: D3575-1

Parent Item Name: Cargo Floor Protector

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	2,684.9900	8	10		Jm14-04-8	
--	--	-----------	----	--	--	-----	----	------------	---	----	--	-----------	--

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	2684.99	
124866	106	
m126425	479.99	
m127934	2099	127934.

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____ Part No. _____ NCR No. _____				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>									
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
FAULT CATEGORY															
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b>			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		

DART AEROSPACE LTD	Work Order:	112274
Description: Cabin Floor Protector	Part Number:	D3575-1
Inspection Dwg: D3575 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

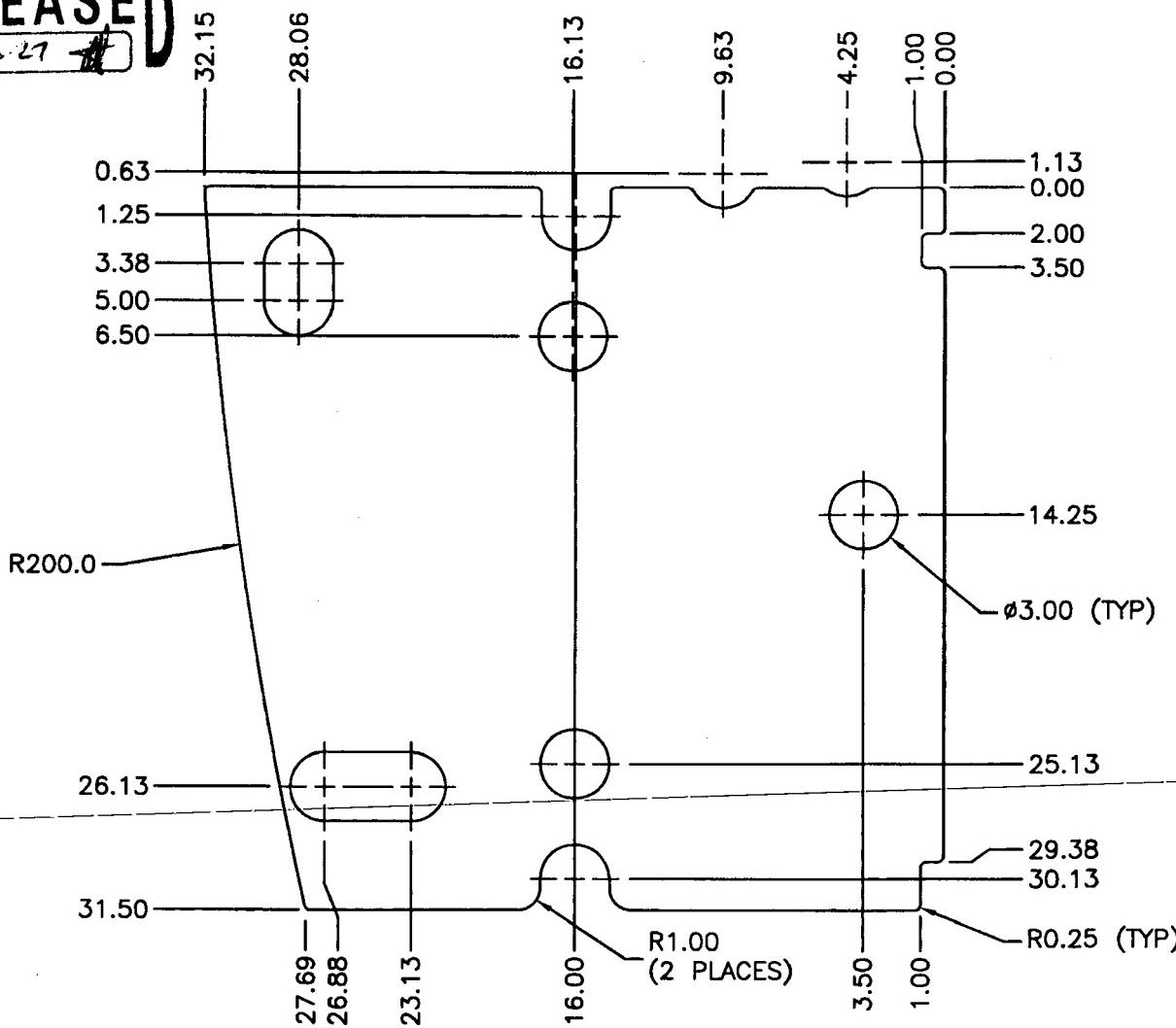
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004"	-		✓	JM
1.00	+/-0.030	1.02"	-		✓	
3.50	+/-0.030	3.50"	-		✓	
16.00	+/-0.030	16.02"	-		T	JM
23.13	+/-0.030	23.3"	-		T	
26.88	+/-0.030	26.88"	-		T	
27.69	+/-0.030	27.69"	-		T	
4.25	+/-0.030	4.25"	-		✓	
9.63	+/-0.030	9.63"	-		✓	JM
16.13	+/-0.030	16.13"	-		T	
28.06	+/-0.030	28.06"	-		T	
32.15	+/-0.030	32.15"	-		T	
2.00	+/-0.030	2.00"	-		✓	
3.50	+/-0.030	3.50"	-		✓	
14.25	+/-0.030	14.25"	-		T	
25.13	+/-0.030	25.13"	-		T	
29.38	+/-0.030	29.38"	-		T	
30.13	+/-0.030	30.13"	-		T	
1.25	+/-0.030	1.25"	-		✓	
3.38	+/-0.030	3.38"	-		✓	
5.00	+/-0.030	5.00"	-		✓	
6.50	+/-0.030	6.50"	-		✓	
26.13	+/-0.030	26.13"	-		T	
31.50	+/-0.030	31.50"	-		T	

Measured by:	JM	Audited by:	27 p.99	Prototype Approval:	N/A
Date:	14/04/8.	Date:	14/4/8	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8
A	07.06.08	NEW ISSUE	

**RELEASED**  
07.06.08

D3575-1 CABIN FLOOR PROTECTOR (SHOWN)  
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

10-11  
10-11  
10-11  
10-11

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

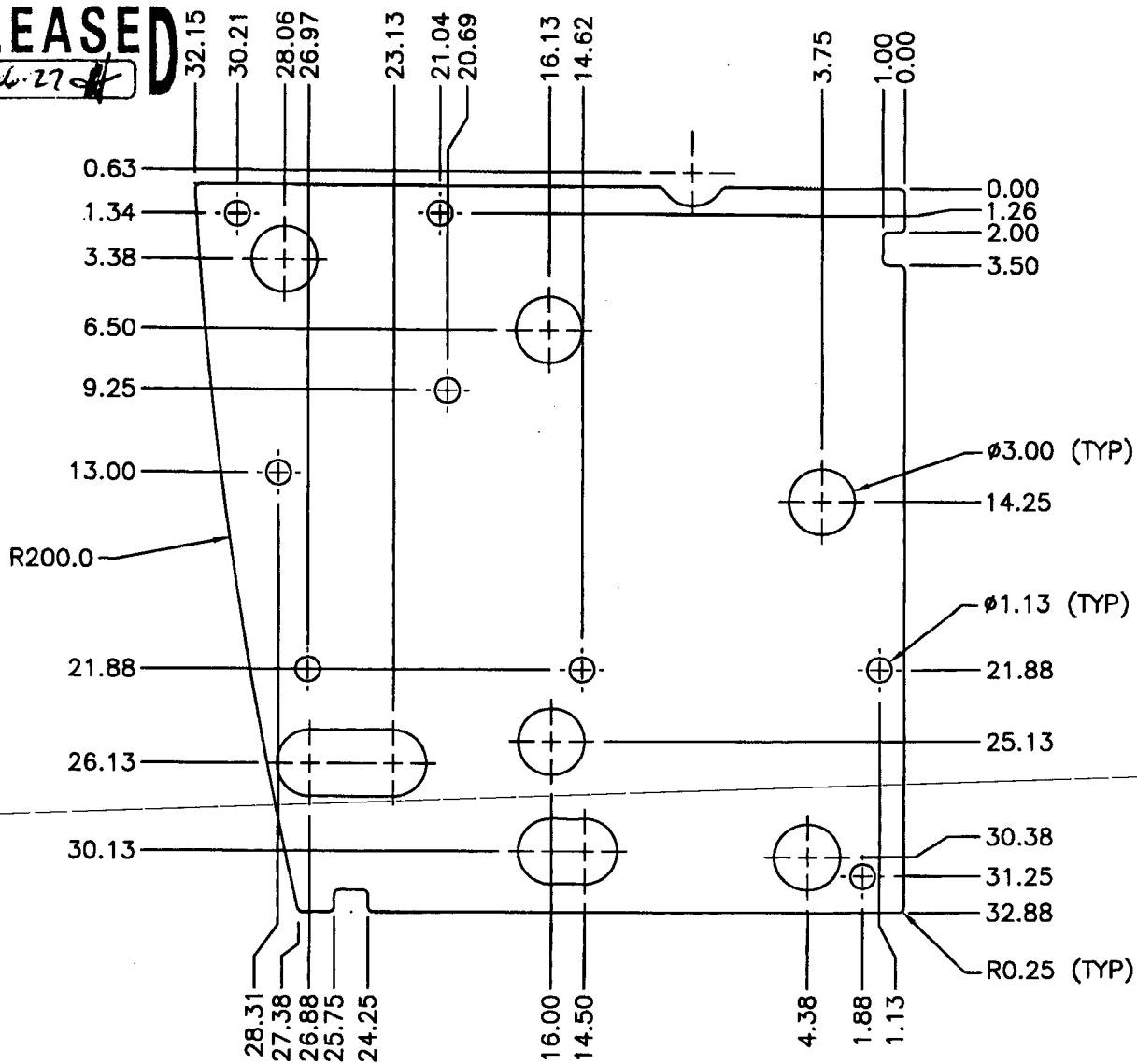
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**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3575	REV. A	SHEET 2 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8	

**RELEASED** 07-06-27 **32.15**



**D3575-3 CABIN FLOOR PROTECTOR**

**NOTES:**

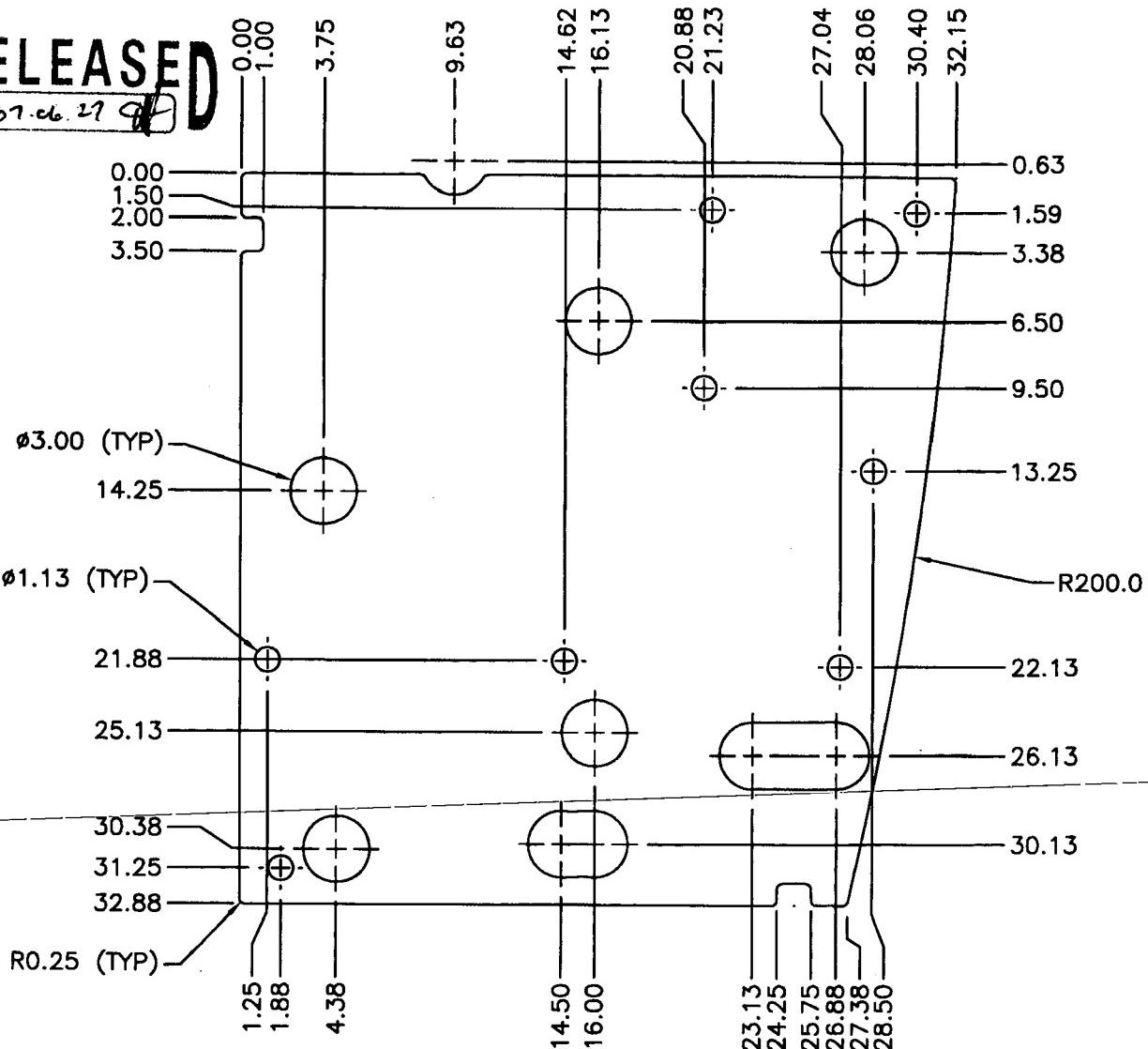
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
  - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
  - 7) CHECK PER TEMPLATE DT8967

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>dt</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**

07.06.27 9:17

**D3575-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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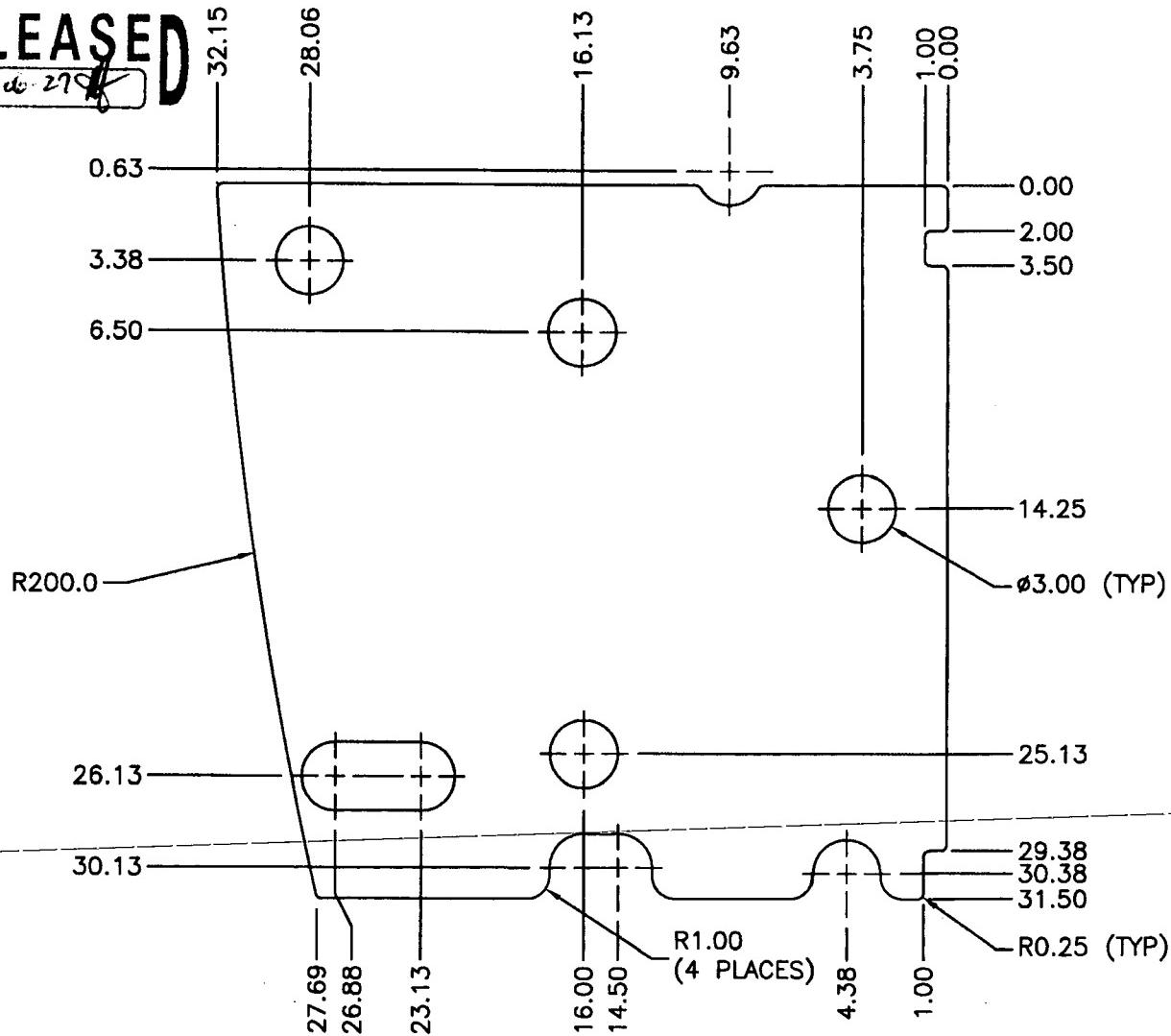
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DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3575	REV. A	SHEET 4 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8	

**RELEASED**  
07-06-2025

07-00-270



D3575-5 CABIN FLOOR PROTECTOR (SHOWN)  
D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
  - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
  - 7) CHECK PER TEMPLATE DT8969

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